Date: Friday, 9/21/2007 1:01:05 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CROSSBOLT SPACER
Job Number	: 34789		
Estimate Number	: 10993		
P.O. Number	: N/A	Part Number	: D2579
This Issue	: 9/21/2007 S.O. No. : N/A	Drawing Number	: D2579 REV E
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: E
Previous Run	: 34347	Material	: N/A
Written By	:	Due Date	: 10/15/2007 Qty: 500 Um: Each
Checked & Approved By	: 07/09/24		
Comment	: Est E 02.06.17 Now turned on Cobra NG est F 07.07.06 rev E dwg EC		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6T0500W058	6061-T6 Tube .500 x.058W

Comment: Qty.: 0.3762 f(s)/Unit Total : 188.1075 f(s) 188.8'
6061-T6 Tube .500 x.058W
Material: 6061-T6 (WW-T-700/6) or 5052-H32 (WW-T-700/4)
0.500 Dia x 0.058 Wall Batch M105804 DJP 07/10/05 RP 07/10/06

2.0	HARDINGE	HARDINGE CNC LATHE SMALL

Comment: HARDINGE CNC LATHE SMALL
Machine as per Folio FA245 DJP 07/10/05 RP 07/10/06

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE DJP 07/10/05 RP 07/10/06

4.0	QC8	SECOND CHECK

Comment: SECOND CHECK JF 07/10/06 545

5.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Identify and Stock
Location:_____ 07/10/09 545

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes (No) **DQA:** ☐ **Date:** 07/08/09

QA: N/C Closed: _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 9/21/2007 1:01:05 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** CROSSBOLT SPACER

Job Number: 34789 **Part Number:** D2579

Job Number:

Seq. #:	Machine Or Operation:	Description :
6.0	QC21	FINAL INSPECTION/W/O RELEASE

345

Comment: FINAL INSPECTION/W/O RELEASE LD 07/10/09

Job Completion

CL07/10/09

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

QA: N/C Closed: _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	34789
Description: Cross Bolt Spacer	Part Number:	D2579
Inspection Dwg: D2579 Rev: ~~D~~ E 07.09.04		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.070	+/-0.030	4.063	✓			
0.058	+/-0.010	0.058	✓			

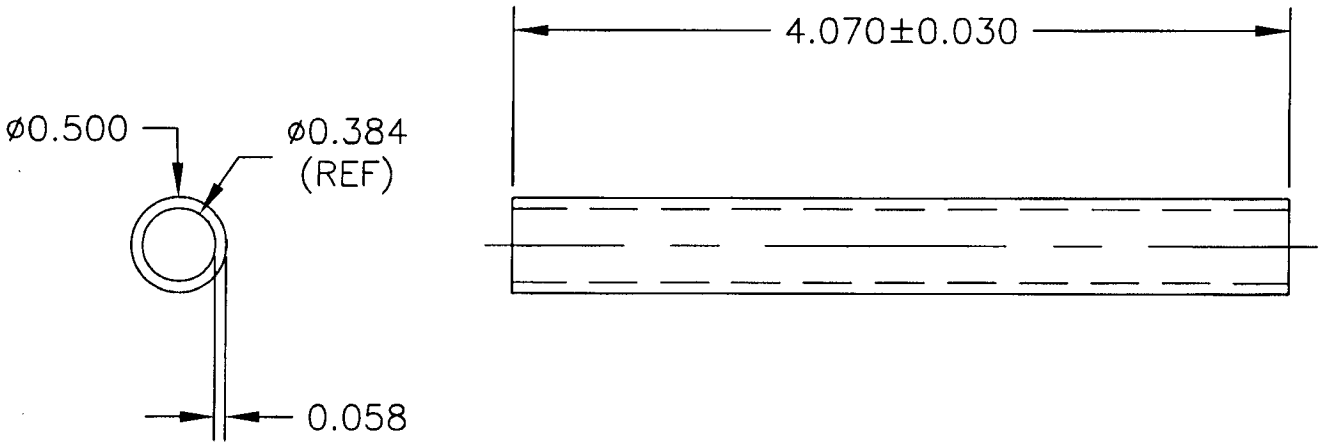
Measured by:	DJP	Audited by:	J.L	Prototype Approval:	N/A
Date:	07/10/05	Date:	07/10/05	Date:	

Rev	Date	Change	Revised by	Approved
A	03.11.27	New Issue	KJ/RF	

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2579	REV. E SHEET 1 OF 1
DATE 07.04.17		TITLE CROSS BOLT SPACER	SCALE 1:1

A	96.09.16	NEW ISSUE
B	96.12.05	0.065 WALL WAS 0.035 WALL
C	97.02.21	0.058 WALL WAS 0.065 WALL
D	99.05.19	4.070 LENGTH WAS 4.100 (TSR A1095)
E	07.04.17	UPDATE NOTES

RELEASED
07.06.28



D2579 CROSS BOLT SPACER

D2579 CROSS BOLT SPACER

1) MATERIAL: 6061-T6 TUBING PER WW-T-700/6 OR QQ-A-200/8 OR QQ-A-225/8 (REF DART SPEC M6061T6T0500W058)
2) FINISH: NONE
3) ALL DIMENSIONS ARE IN INCHES
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 34789